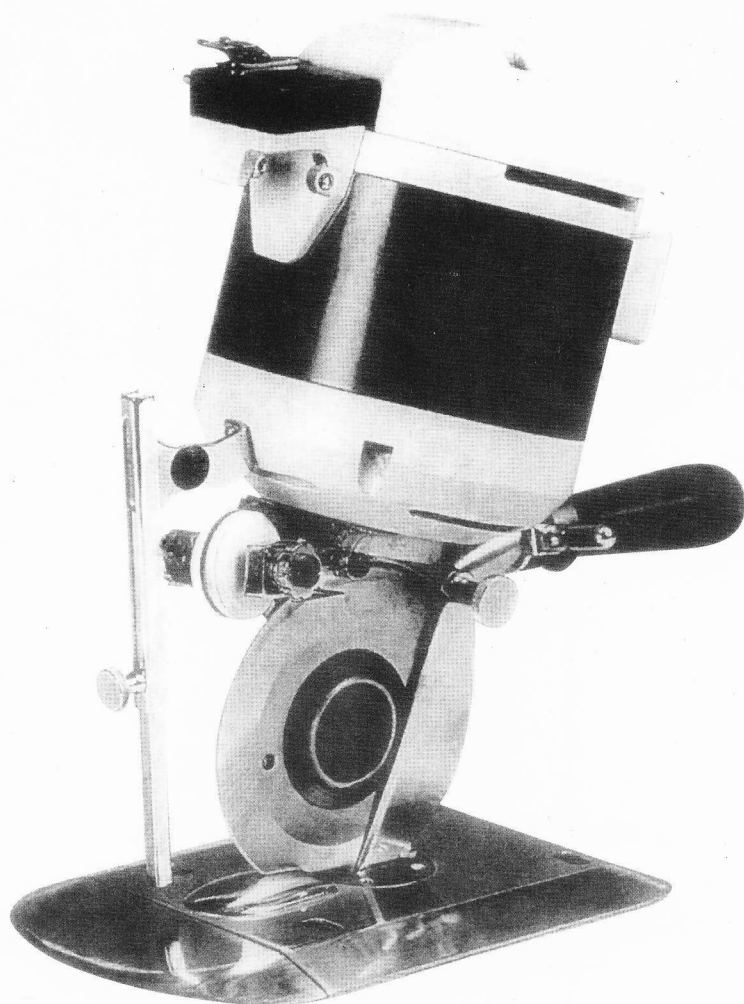


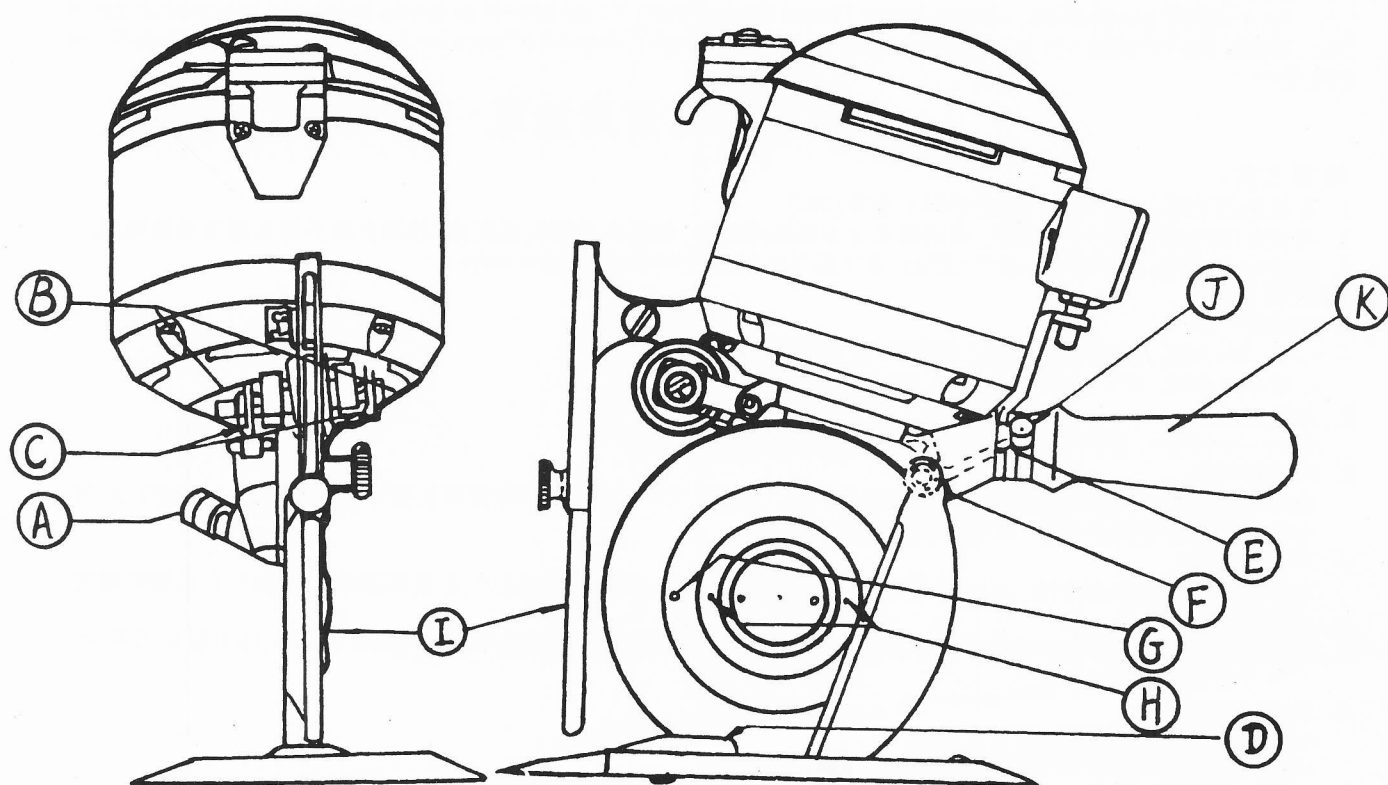
# ROUND KNIFE CUTTING MACHINE OPERATION AND PARTSLIST



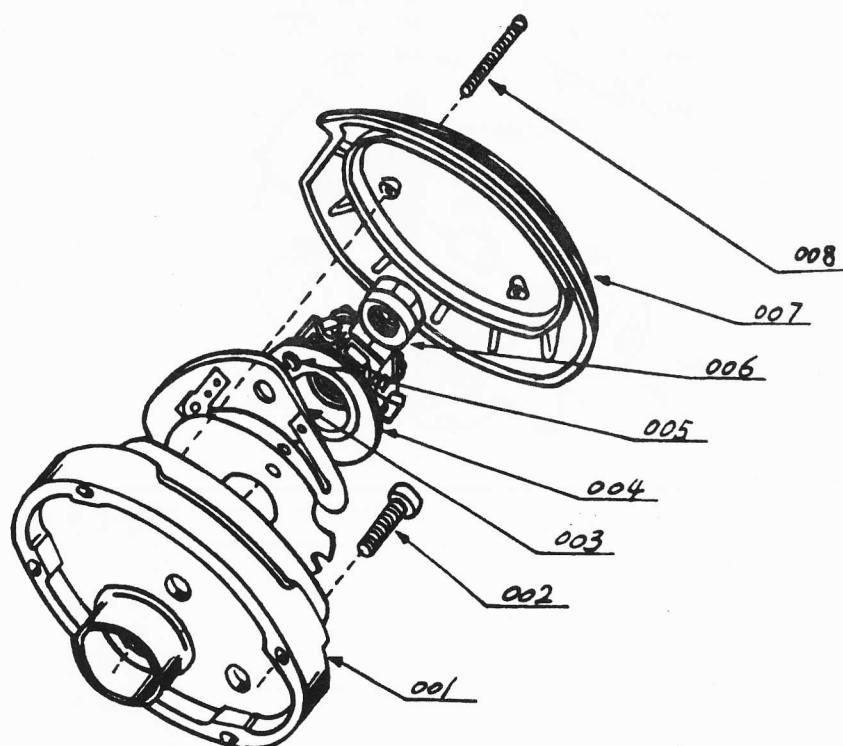
**CAUTION**  
Machine Equipped  
With  
Sharp Blade

圓刀裁剪機使用說明及零件目錄

# OPERATION - LUBRICATION - CARE

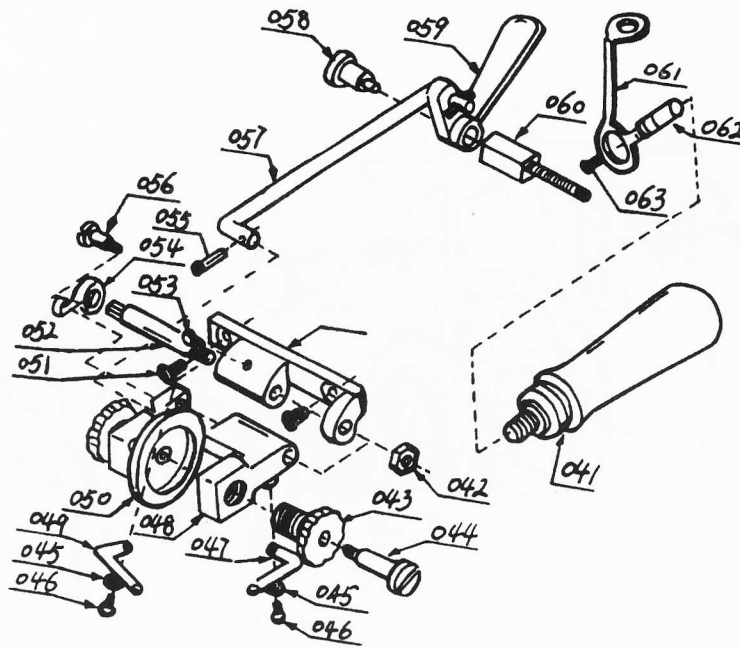


# REAR BEARING HOUSING ASSEMBLY



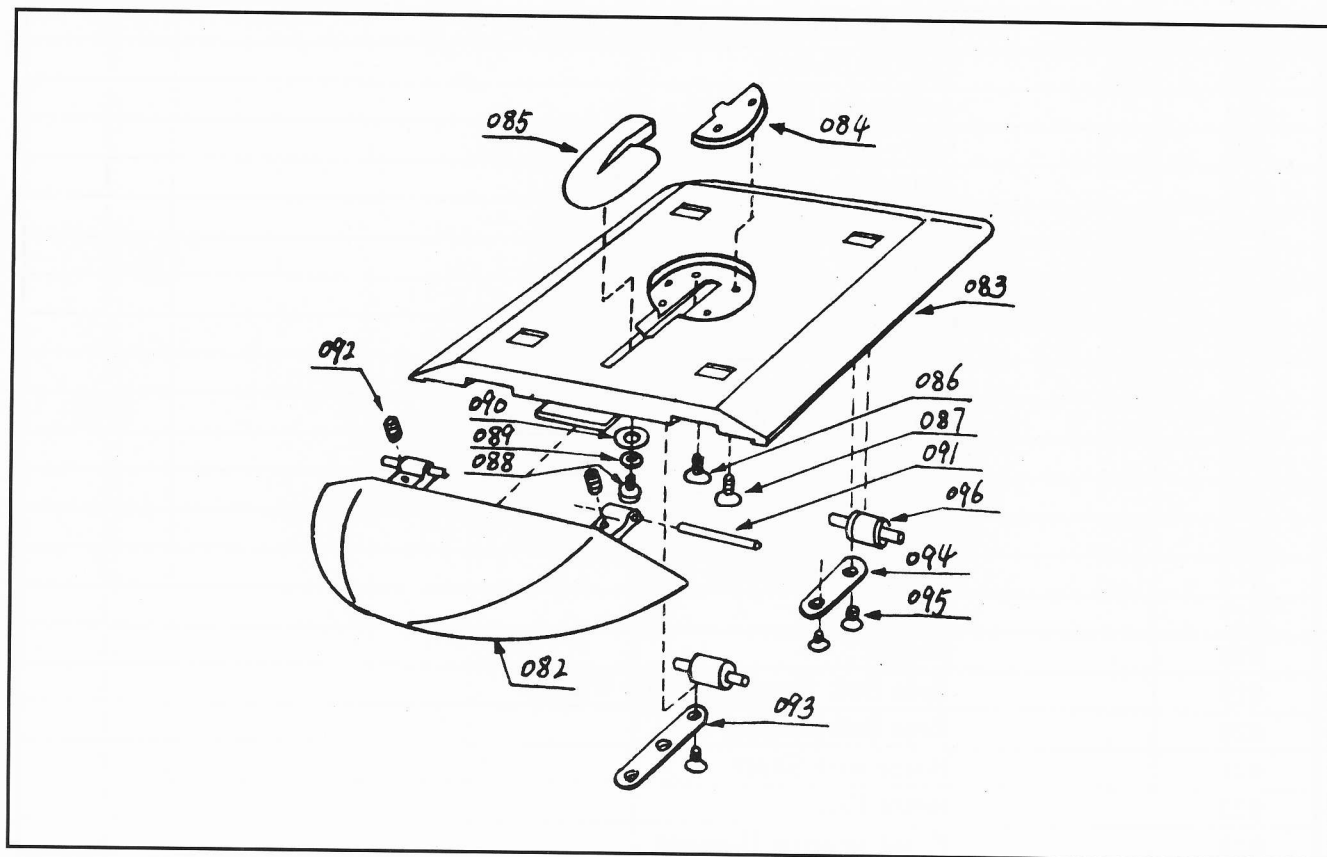
|     |                             |           |
|-----|-----------------------------|-----------|
| 001 | Rear Bearing Housing        | 后轴承盖      |
| 002 | Rear Bearing Housing Screw  | 后轴承盖螺钉    |
| 003 | Cut - Out Switch            | 断路开关      |
| 004 | Automatic Cut - Out         | 自动断路器     |
| 005 | Cut - Out Set Screw         | 断路开关螺钉    |
| 006 | Automatic Cut - Out Fix Nut | 自动断路器固定螺钉 |
| 007 | Dust Cap                    | 防尘盖       |
| 008 | Dust Cap Screw              | 防尘盖螺钉     |

# SHARPENING ASSEMBLY



|     |                             |          |
|-----|-----------------------------|----------|
| 041 | Operating Handle            | 操作手柄     |
| 042 | Grinder Shaft Lock Nut      | 砂轮架轴固定螺母 |
| 043 | Grinder Adjusting Screw     | 砂轮调整螺栓   |
| 044 | Grinder Set Screw           | 砂轮轴位螺钉   |
| 045 | Grinder Adj. Set Washer     | 砂轮调整装置垫圈 |
| 046 | Grinder Adj. Set Screw      | 砂轮调整装置螺钉 |
| 047 | Grinder Adjusting Spring(R) | 砂轮调整右弹簧  |
| 048 | Grinder Frame               | 砂轮架      |
| 049 | Grinder Adjusting Spring(L) | 砂轮调整左弹簧  |
| 050 | Emery Wheel                 | 砂轮       |
| 051 | Grinder Arm Screw           | 砂轮架支座螺钉  |
| 052 | Grinder Shaft               | 砂轮架轴     |
| 053 | Grinder Frame Stopper Screw | 砂轮架限位螺钉  |
| 054 | Grinder Spring              | 砂轮架弹簧    |
| 055 | Set Pin                     | 开口销      |
| 056 | Grinder Spring Set Screw    | 砂轮架弹簧螺钉  |
| 057 | Sharpening Link             | 磨刀连杆     |
| 058 | Sharpening Lever Set Screw  | 磨刀曲柄支架螺钉 |
| 059 | Sharpening Leve             | 磨刀曲柄     |
| 060 | Sharpening Lever Frame      | 磨刀曲柄支架   |
| 061 | Switch Link                 | 开关连杆     |
| 062 | Switch Knob                 | 开关捏手     |
| 063 | Switch Knob Set Screw       | 开关捏手螺钉   |
| 064 | Grinder Arm                 | 砂轮架支架    |

# BASE PLATE ASSEMBLY

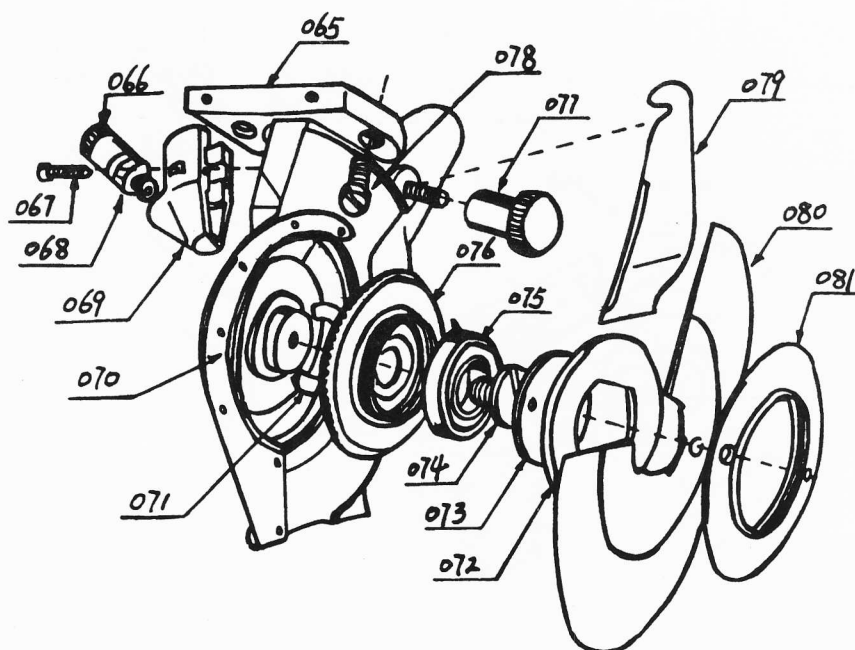


|     |                            |        |
|-----|----------------------------|--------|
| 082 | Plate Wing                 | 底板舌    |
| 083 | Base Plate                 | 底板     |
| 084 | Knife Cover Plate          | 护刀板座   |
| 085 | Throat Plate               | 刀板     |
| 086 | Standard Set Screw         | 刀架螺钉   |
| 087 | Knife Cover Plate Screw    | 护刀板座螺钉 |
| 088 | Throat Plate Set Screw     | 刀板螺钉   |
| 089 | Throat Plate Spring Washer | 刀板弹簧垫圈 |
| 090 | Throat Plate Washer        | 刀板垫圈   |
| 091 | Hinge Pin Short            | 连接销轴   |
| 092 | Plate Wing Tension Spring  | 底板舌弹簧  |
| 093 | Clip(L)                    | 长压板    |
| 094 | Clip(S)                    | 短压板    |
| 095 | Clip Set Screw             | 压板螺钉   |
| 096 | Roller                     | 滚轮     |

| Fig No. | Name of Part                | Qt. req |
|---------|-----------------------------|---------|
| 049     | Grinder Adjusting Spring(L) | 1       |
| 050     | Emery Wheel                 | 2       |
| 051     | Grinder Arm Screw           | 2       |
| 052     | Grinder Shaft               | 1       |
| 053     | Grinder Frame Stopper Screw | 1       |
| 054     | Grinder Spring              | 1       |
| 055     | Set Pin                     | 2       |
| 056     | Grinder Spring Set Screw    | 1       |
| 057     | Sharpening Link             | 1       |
| 058     | Sharpening Lever Set Screw  | 1       |
| 059     | Sharpening Lever            | 1       |
| 060     | Sharpening Lever Frame      | 1       |
| 061     | Switch Link                 | 1       |
| 062     | Switch Knob                 | 1       |
| 063     | Switch Knob Set Screw       | 1       |
| 064     | Grinder Arm                 | 1       |
| 065     | Standard                    | 1       |
| 066     | Grease Rup Nut              | 1       |
| 067     | Gear Cover Screw            | 2       |
| 068     | Grease Rup                  | 1       |
| 069     | Gear Cover                  | 1       |
| 070     | Standard Cover              | 1       |
| 071     | Knife Gear Adjusting Washer | 按需      |
| 072     | Grease Cover                | 1       |
| 073     | Knife Gear Bearing Seal     | 1       |
| 074     | Knife Gear Bearing Screw    | 1       |
| 075     | Knift Gear Bearing          | 1       |
| 076     | Knife Gear                  | 1       |
| 077     | Knife Cover Set Nut         | 1       |
| 078     | Standard Set Screw          | 3       |
| 079     | Knife Cover                 | 1       |
| 080     | Round Knife                 | 1       |
| 081     | Knife Set Nut               | 1       |
| 082     | Plate Wing                  | 1       |
| 083     | Base Plate                  | 1       |
| 084     | Knife Cover Plae            | 1       |
| 085     | Throat Plate                | 1       |
| 086     | Standard Set Screw          | 3       |
| 087     | Knife Cover Plate Screw     | 2       |
| 088     | Throat Plate Set Screw      | 1       |
| 089     | Throat Plate Spring Washer  | 1       |
| 090     | Throat Plate Washer         | 1       |
| 091     | Hinge Pin Short             | 2       |
| 092     | Plate Wing Tension Spring   | 2       |
| 093     | Clip(L)                     | 2       |
| 094     | Clip(S)                     | 2       |
| 095     | Clip Set Screw              | 10      |
| 096     | Poller                      | 4       |

| Fig No. | Name of Part                    | Qt. req |
|---------|---------------------------------|---------|
| 001     | Rear Bearing Housing            | 1       |
| 002     | Rear Bearing Housing Screw      | 4       |
| 003     | Cut Out Switch                  | 1       |
| 004     | Automatic Cut – Out             | 1       |
| 005     | Cut – Out Set Screw             | 2       |
| 006     | Automatic Cut – Out Fix Nut     | 1       |
| 007     | Dust Cap                        | 1       |
| 008     | Dust Cap Screw                  | 3       |
| 009     | Front Bearing Housing Screw     | 4       |
| 010     | Rotor Fan Plate                 | 1       |
| 011     | Driving Gear                    | 1       |
| 012     | Driving Gear Washer             | 按需      |
| 013     | Driving Gear Collar             | 1       |
| 014     | Front Ball Bearing Retainer     | 1       |
| 015     | Front Ball Bearing              | 1       |
| 016     | Switch Box Screw                | 2       |
| 017     | Switch Box                      | 1       |
| 018     | Switch                          | 1       |
| 019     | Rear Ball Bearing Spring Washer | 1       |
| 020     | Rear Ball Bearing               | 1       |
| 021     | Rotor with Shart                | 1       |
| 022     | Rotor Fan                       | 1       |
| 023     | Front Bearing Housing           | 1       |
| 024     | Guard Plate                     | 1       |
| 025     | Guard Holder Nut                | 1       |
| 026     | Guard Plate Screw               | 2       |
| 027     | Guard Shaft Adjusting Screw     | 1       |
| 028     | Guard Holder                    | 1       |
| 029     | Guard Holder Screw              | 1       |
| 030     | Guard Shaft                     | 1       |
| 031     | Capacitor – Stator              | 1       |
| 032     | Lift Handle                     | 1       |
| 033     | Lift Handle Screw               | 1       |
| 034     | Terminal Sleeve                 | 2       |
| 035     | Attachment Plug(Complete)       | 1       |
| 036     | Ground Clip                     | 1       |
| 037     | Ground Clip Screw               | 1       |
| 038     | Terminal Block Screw            | 1       |
| 039     | Terminal Contact with Screw     | 2       |
| 040     | Terminal Block(Complete)        | 1       |
| 041     | Operating Handle                | 1       |
| 042     | Grinder Shaft Lock Nut          | 1       |
| 043     | Grinder Adjusting Screw         | 2       |
| 044     | Grinder Set Washer              | 1       |
| 045     | Grinder Adj. Set Screw          | 2       |
| 046     | Grinder Adj. Set Screw          | 2       |
| 047     | Grinder Adjusting Spring(R)     | 1       |
| 048     | Grinder Frame                   | 1       |

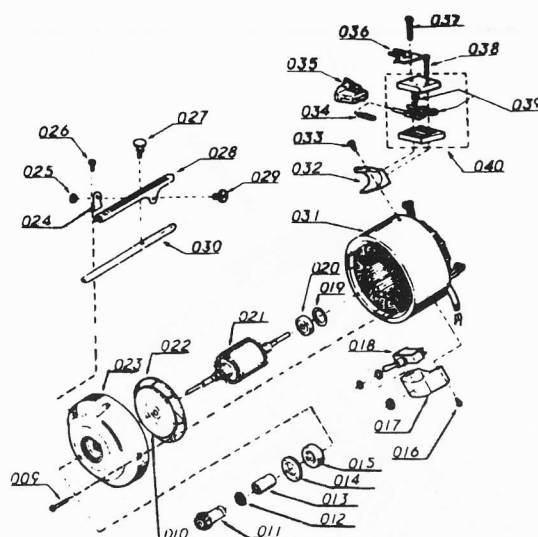
# STANDARD ASSEMBLY



|     |                             |          |
|-----|-----------------------------|----------|
| 065 | Standard                    | 刀架       |
| 066 | Grease Rup Nut              | 油杯盖      |
| 067 | Gear Cover Screw            | 齿轮罩螺钉    |
| 068 | Grease Rup                  | 油杯       |
| 069 | Gear Cover                  | 齿轮罩      |
| 070 | Standard Cover              | 刀架保护板    |
| 071 | Knife Gear Adjusting Washer | 刀片齿轮调整垫片 |
| 072 | Grease Cover                | 防油罩      |
| 073 | Knife Gear Bearing Seal     | 刀片齿轮轴承盖  |
| 074 | Knife Gear Bearing Screw    | 刀片齿轮轴承螺钉 |
| 075 | Knife Gear Bearing          | 刀片齿轮轴承   |
| 076 | Knife Gear                  | 刀片齿轮     |
| 077 | Knife Cover Set Nut         | 护刀板螺母    |
| 078 | Standard Set Screw          | 刀架螺钉     |
| 079 | Knife Cove                  | 护刀板      |
| 080 | Round Knife                 | 圆刀片      |
| 081 | Knife Set Nut               | 刀片拼紧螺母   |



# MOTOR & GUARD ASSEMBLY



|     |                                 |          |
|-----|---------------------------------|----------|
| 009 | Front Bearing Housing Screw     | 前轴承盖螺钉   |
| 010 | Rotor Fan Plate                 | 风叶盖板     |
| 011 | Driving Gear                    | 主动齿板     |
| 012 | Driving Gear Washer             | 主动齿轮调整垫片 |
| 013 | Driving Gear Collar             | 主动齿轮轴套   |
| 014 | Front Ball Bearing Retainer     | 前轴承挡圈    |
| 015 | Front Ball Bearing              | 前轴承      |
| 016 | Switch Box Screw                | 开关罩壳螺钉   |
| 017 | Switch Box                      | 开关罩壳     |
| 018 | Switch                          | 开关       |
| 019 | Rear Ball Bearing Spring Washer | 后轴承波形垫圈  |
| 020 | Rear Ball Bearing               | 后轴承      |
| 021 | Rotor with Shaft                | 转子总成     |
| 022 | Rotor Fan                       | 风叶       |
| 023 | Front Bearing Housing           | 前轴承盖     |
| 024 | Guard Plate                     | 保护架座     |
| 025 | Guard Holder Nut                | 保护架螺母    |
| 026 | Guard Plate Screw               | 保护架座螺钉   |
| 027 | Guard Shaft Adjusting Screw     | 保护杆调整螺钉  |
| 028 | Guard Holder                    | 保护架      |
| 029 | Guard Holder Screw              | 保护架螺钉    |
| 030 | Guard Shaft                     | 保护杆      |
| 031 | Capacitor - Stator              | 定子总成     |
| 032 | Lift Handle                     | 拎攀       |
| 033 | Lift Handle Screw               | 拎攀螺钉     |
| 034 | Terminal Sleeve                 | 插头芯      |
| 035 | Attachment Plug( Complete)      | 插头       |
| 036 | Ground Clip                     | 接地线夹     |
| 037 | Ground Clip Screw               | 接地线夹螺钉   |
| 038 | Terminal Block Screw            | 插座螺钉     |
| 039 | Terminal Contact with Screw     | 插脚       |
| 040 | Terminal Block ( Complete)      | 插座       |

# Operating Instruction

## BEFORE USE

- A. Fit Operating Handle(041) and Switch Link(061) and Switch Knob (062).
- B. Insert Attachment Plug (035) into Terminal Contact (040) and fasten Terminal Clip(036) firmly with screw located on the upperside of Plug, to prevent it falling out due to the machine vibration.
- C. Insert the plug into an electric power source and turn on Switch Knob (062) upwards. Sharpen the knife by pressing Sharpening LeverE(059) down several times.

## LUBRICATION AND CARE

### A. GREASING

- (1) Every 100 hours: grease the machine by screwing Cap of Grease Cup A (066) down slightly.
- (2) Every 300 hours: refill Grease Cup with grease by removing CapA(066) and filling Cup with grease.

### B. OILING

Lubricate Grinder Set Screw B(059) with a few drops of oil every 40 – 50 hours.

### C. ADJUSTING EMERY WHEELS

When Emery Wheels become worn, the angle between Emery Wheels and Knife changes and dulls the edge of Knife. To adjust, screw Right and Left Grinder Adjust – ing Screws C (043) towards the center the same number of turns and obtain the original gap again.

### D. REPLACING THE EMERY WHEELS

To remove, hold Emery Wheel by hand to prevent them from turning and unscrew Grinder Set Screw B with a screw driver(turn it to the left i. e. anticlockwise). Fit the new Emery Wheels in the reverse sequence.

### E. ADJUSTING THE THROAT PLATE

When the knife has become worn, it is necessary to re – set the gap between Knife and Throat Plate D (099). To make this adjustment, loosen Throat Plate Set Screw(092) and move Throat Plate towards Knife.

### F. REPLACING KNIFE

- (1) Loosen Knife Cover Set Nut F(077) and remove Knife Cover(079).
- (2) Loosen Throat Plate Set Screw (092) and move Throat Plate D away from Knife.
- (3) Line up the hole in Knife G and the hole in Standard(065) and then insert a screwdriver through them to lock them together.
- (4) Use Spanner Wrench and turn Knife Set Nut H (081) to the left i. e. anticlockwise.
- (5) Fit Knife in the reverse sequence.

## CAUTION

As a safety precaution, always lower Guard Shaft I(030) to its lowest position when the machine is not in use. When the machine is in use, the end of Guard Shaft I should always be kept as near to the cloth as possible.

## 圆刀裁剪机使用说明

### 使用之前:

1. 安装操作手柄(041)及开关连杆(061)、握手(062)。
2. 将插头(035)与插座(040)相连,并将插头上方的螺母旋紧,使插座与插头相固定,以防止插头因机器震动而松脱。
3. 接通电源,并向上扳动开关握手(062),按下磨刀曲柄 E(059)数次,使刀片锋利。

### 润滑和保养:

#### 1. 加油脂:

- a. 每 100 小时,将油杯盖 A(066)慢慢旋进,以给机器加油脂。
- b. 每 300 小时,卸下油杯盖 A(066),补充并加满油脂。

#### 2. 加机油:

每 40 ~ 50 小时,给砂轮调整螺栓 C(043)处,加几滴机油。

#### 3. 砂轮的调整:

当砂轮磨损后,砂轮与刀片之间的角度发生变化,使刀片刃口变钝,此时可调整左右砂轮调整螺栓 C(043),并向中心方向旋转相同的圈数,以重新获得原有的间隙。

#### 4. 砂轮的更换:

用手抓住砂轮,防止它转动,再用螺丝刀向左逆时针方向旋松砂轮轴位螺钉 B,安装新砂轮的步骤与上述顺序相反。

#### 5. 刀板的调整:

当刀片磨损后,必须重新调整刀片与刀板 D(099)的间隙,调整时,先旋松刀板紧固螺钉 (092),将刀板向刀片方向移适当距离。

#### 6. 刀片的更换:

- a. 旋松护刀板螺母(077),卸下护刀板 (079)。
- b. 旋松刀板紧固螺钉(092),移动刀板 D,使其脱离刀片。
- c. 将刀片上的小孔 G 与刀架(065)上的孔对齐,并插入螺丝刀,使它们无相对转动。
- d. 用专用扳手向左逆时针方向旋下刀片紧螺母 H(081)。
- e. 安装刀片步骤与上述顺序相反。

### 注意:

从安全考虑,当机器不用时,应把保护杆 I(030)降到最低位置,当机器使用时,保护杆 I 的底部应尽量靠近布料。